

Work Order ID 64346



Page 1

Friday, December 03, 2010 11:46:35 AM

Item ID: D407-802-017

Accept



Setup Start



Revision ID:

Stop



Item Name: Passenger Door Opener Installation, LH

Start Date: 12/2/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

PH

Date:

10-12-3

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D407-802-1

A

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and create labels per PPP D407-802-017 CHG001

8/10/05/20

CL 11-5-30

105



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

PH => 11/05/27

110



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

8/10/05/20

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D407-802-017

Accept



Setup Start



Revision ID:

Stop



Item Name: Passenger Door Opener Installation, LH

Start Date: 12/2/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD407-802-017 Location: _____ PPP rev: _____								
130 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

12/15/30 *(2)*

11/15/31 *(2)*

11-05-30 *(2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, December 03, 2010 11:46:39 AM

Page 1

Work Order ID: 64346

Parent Item: D407-802-017

Parent Item Name: Passenger Door Opener Installation, I H

Start Date: 12/2/2010

Required Date: 12/5/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC
10.12.03 as per dwg rev.A DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21209F1-15

Purchased

No

105

Each

14.0000

3

6

✓



HELI COIL

Location

Loc Qty

Loc Code

ST304

14

104537

14

D3552-15

Manufactured

No

105

Each

1.0000

2

✓



Door Prop

Location

Loc Qty

Loc Code

ST272A

1

63012

1

D3622-5

Manufactured

No

105

Each

0.0000

2

✓



Ball Stud

D4108-1

Manufactured

No

105

Each

4.0000

1

✓



Door Doubler, Left

Location

Loc Qty

Loc Code

ST129

4

62301

4

D4108-049

Manufactured

No

105

Each

1.0000

1

✓



Litter Door Fitting Assembly

Location

Loc Qty

Loc Code

ST

1

62306

1

JB R

104537

2

64402

JB R

ATO

2

64330

JB R

2

JB R

62301

2

64490

JB R

11/05/27

W/O: 64346

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D407-800-017 PAR #: N/A Fault Category: Production Engineering NCR: Yes No DQA: 11 Date: 11.11.03
 Resolution: Re-work Disposition: Re-work QA: N/C Closed Date: 11/11/04

NCR: 11.9.03		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/5/30	#105	wrong part in pick list should be D3552-17 NOT D3552-15. R.C. Berr + wlo not correct correctly here	CP 11.05.31 PSJWZ	→ Remove D3552-15 AND Replace D3552-17 B 64338	11/5/30	11/5/30	CP 11.05.31 PSJWZ	11/5/30
			CP 11.05.31	ADD copy of Berr to show correction for Ref. only	11.05.30	11.05.30	CP 11.05.31	11/5/30

NOTE: Date & initial all entries

Picklist Print

Friday, December 03, 2010 11:46:39 AM

Page 2

Work Order ID: 64346

Parent Item: D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 2.00

Required Qty: 2.00

CR3523-4-03

Purchased

No

105

Each

137.0000

21

42

✓



RIVET



JB R

Location

Loc Qty

Loc Code

ST313

137

112991

137

112991

MS20426AD4-5

Purchased

No

105

Each

5,731.000

2

4



Rivet



JB R

Location

Loc Qty

Loc Code

ST317

5731

6733

749

6874

4982

6733

MS21073L5

Purchased

No

105

Each

74.0000

1

2

✓



nut plate



JB R

Location

Loc Qty

Loc Code

ST303

74

113660

74

113660

MS27039C1-06

Purchased

No

105

Each

94.0000

3

6

✓



Screw



JB 11/05/27

Location

Loc Qty

Loc Code

ST293

94

115768

94

115768

Friday, December 03, 2010 11:46:39 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Friday, December 03, 2010 11:46:39 AM

Page 3

Work Order ID: 64346

Parent Item: D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 2.00

Required Qty: 2.00

MS27039C1-09

Purchased

No

105

Each

149.0000

1

2

✓



SCREW



JB

Location

Loc Qty

Loc Code

ST293

149

116290

100

17831

49

MS27039C1-27

Purchased

No

105

Each

46.0000

2

4

✓



Screw



JB

Location

Loc Qty

Loc Code

ST293

46

115768

46

NAS1149C0332R

Purchased

No

105

Each

6,145.0000

2

4

✓



Washer



115768

4

117291

JB

Location

Loc Qty

Loc Code

ST297

6145

115000

125

115698

35

115832

985

116025

2000

116304

3000

NAS1149C1165R

Purchased

No

105

Each

96.0000

2

4

✓



Washer



JB 11/05/27

Location

Loc Qty

Loc Code

ST297

96

115768

96

115768

Friday, December 03, 2010 11:46:39 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 4

Work Order ID: 64346

Parent Item: D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 12/2/2010

Required Date: 12/5/2010

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0532R

Purchased

No

105

Each

278.0000

6

12 ✓



WASHER



116513 JB

Location

Loc Qty

Loc Code

ST297

278

114348

8

115531

70

116289

200

NAS1149C0563R

Purchased

No

105

Each

148.0000

6

12 ✓



Washer



115768 JB 11/05/27

Location

Loc Qty

Loc Code

ST297

148

115768

148

115768

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D407-802-1
Page 27 of 28

5.3 D407-802-017/-018 Passenger Door Opener Kits

Qty -017	Qty -018	Part Number	Description
		D407-802-017	PASSENGER DOOR OPENER KIT, LH
		D407-802-018	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	1	D3622-5	BALL STUD
1		D4108-1	DOOR DOUBLER, LEFT
	1	D4108-3	DOOR DOUBLER, RIGHT
	1	D4108-5	SMALL RIGHT DOOR DOUBLER
	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
1		D4108-049	LITTER DOOR FITTING ASSEMBLY
	19	CR3523-4-2	RIVET
21		CR3523-4-3	RIVET
	4	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
	2	MS20426AD4-6	RIVET
1	1	MS21073L5	ANCHOR NUT
3		MS21209-F1-15	HELICOIL
3		MS27039C1-06	SCREW
1		MS27039C1-09	SCREW
2	2	MS27039C1-27	SCREW
2	2	NAS1149C0332R	WASHER
2	2	NAS1149C1165R	WASHER
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.4 D407-802-019 Baggage Door Opener Kit, Composite

Qty -019	Part Number	Description
	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
1	D3552-19	DOOR PROP
1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
1	D4109-043	DOUBLER ASSEMBLY
3	80-004-2-6	INSERT
4	MS27039C1-05	SCREW
3	MS27039C1-06	SCREW
7	NAS1149C0363R	WASHER
4	NAS1836-3-08M	INSERT

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Revision: A
Date: 10.10.13